

Date: Monday, 05/01/2009 7:57:33 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SPACERS (5/16 THICK)
<b>Job Number</b> : 44353	
<b>Estimate Number</b> : 10248	
<b>P.O. Number</b> :	<b>Part Number</b> : D2022103
<b>This Issue</b> : 05/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2022 REV. -
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : -
<b>Previous Run</b> : 38329	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/01/2009 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JL 08.01.5</u>	
<b>Comment</b> : Est D 02.03.07 Now made in house NG	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0750	6061-T6 Round Bar .750"
<b>Comment:</b> Qty.: 0.0329 f(s)/Unit Total : 1.3146 f(s) 6061T6 Round Bar .750" Material: 6061-T6 (QQ-A-225/8)x.7500 bar (M6061T6RO.750) Batch: <u>M1109807</u> <u>ml 09/01/09</u> (40)		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> HARDINGE CNC LATHE SMALL 1- Note: .323 ( P ) Dia drill. 2-Turn Blank as per FolioFA207 3-Tumble & deburr any sharp edges as per dwg <u>ml 09/01/09</u> (40)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 09/01/09</u> (40)		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <u>JL 09/01/11</u> (40)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<b>Comment:</b> PACKAGING RESOURCE #1 Identify and Stock Location: <u>9</u> <u>9/1/12</u> (40x) <u>sq</u>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 05/01/2009 7:57:33 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACERS (5/16 THICK)

Job Number: 44353

Part Number: D2022103

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/12 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF 09-01-12*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

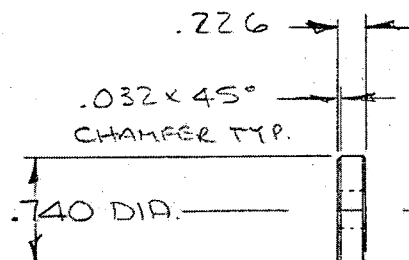
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
970114 Bu



D2022-101  
D2022-103

DRILL 'F' (.257) DIA. IN -101  
DRILL 'P' (.323) DIA IN -103

MAT'L : ALUMINUM 6061-T6 (QQ-A-225/8)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 14353  
WORK ORDER



D2022

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
D2022-103		SPACER 5/16	ALUM. 6061-T6	QQ-A-250/8
D2022-101		SPACER 1/4	ALUM. 6061-T6	QQ-A-250/8

REVISION DRAWN APPROVED DESCRIPTION OF CHANGE	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		QTY. REQUIRED APPROVAL	CONTRACT NO.		DART AERO ACCESSORIES INC	
	REQUIREMENTS - UNLESS OTHERWISE SPECIFIED		BASIC CODE			DRAWN BY BRADLEY		DATE 400612	
	GENERAL		D-COMPLE DRAWING OF SHEETS C-COUNTERSINK			DESIGN BY BRADLEY		TITLE SPACERS	
	LIMITS		BASIC CODES			STRESS		CODE D2022	
1. DIMENSIONS ARE IN INCHES 2. SURFACE FINISHES TO 3. REMOVE CHAMFER EDGES 0.18 MAX 4. THREADS PER IN. - S - 3242 5. HOLES PER AND 10567		1. TOLERANCES - .001 2. ANGLES 3. PARALLELISM 4. PERPENDICULARITY 5. SYMMETRY ABOUT ALL HOLE CENTRE LINES 0.05		DRA. DASH NO. W-HEAD NEAR BOX F-HEAD FAR BOX LENGTH DASH NO. W-SPOTWELD		CHECKED		REV.	
REPORT ALL DISCREPANCIES - DO NOT SCALE									